

Work Order ID 84006 - 2

May-01-12 10:40:07 AM

84006

Split

Page 1

Item ID: D2332-041

Revision ID:

Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012 Start Qty: 10.00

Required Date: 15/05/2012 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: MJS

QC:

Date: 13/05/01 Tooling:

Date: SPC (Y/N):

N9000040100

Cust Item ID:

Customer:

Setup Start

NS1

Stop

NS2

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

1000

Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00

110

Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10

4

FF
12-03-12

10

4

FF
12-03-12

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QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NS1

NS2

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

120

Small Fab

Small Fab

Memo

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

QC5- Inspect part completeness to step on W/O

130

130

QC

Quality Control

Memo

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M114587

140

140

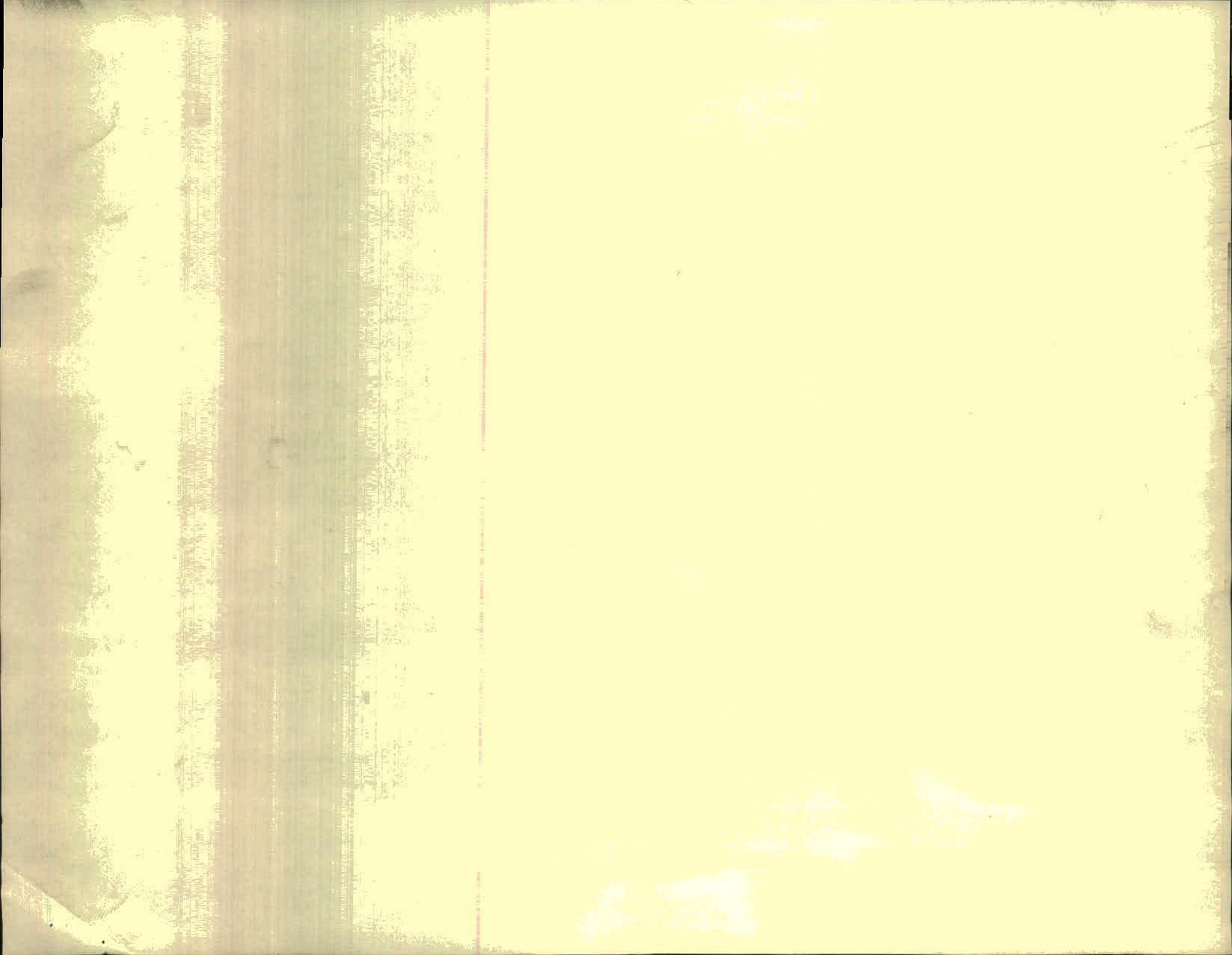
Large Fab

Large Fab

Memo

4

EL 12-8-13



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Required Date: 15/05/2012 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

150

QC

Memo

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

Quality Control

170

170

Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

DAS
10
9-83

12-08-13

(4)

DAS
16
9-83

12/06/13

(24)

ME 12-08-13
FF 12-08-13

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Required Date: 15/05/2012 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
16
S-53

12/05/13

44

190

190

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

4) 12/05/13

12/05/17

12-08-14



Picklist Print

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Work Order ID: 84006

84006

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12Re-format: Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.250		Purchased	No			100	f	14.5500	0.1	1.052632			
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M304R 250

304 SS Round bar .250

**

Location	Loc Qty	Loc Code
MAT028	14.55	
114482	2.55	
120243	12	

M304TR1.000W.049		Purchased	No			100	f	60.0000	0.43	4.526316			
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M304TR1 000W 049

304 RD Tube 1.00 x .049W

**

Location	Loc Qty	Loc Code
MAT018	60.000015	
117598	0.000015	
120654	60	

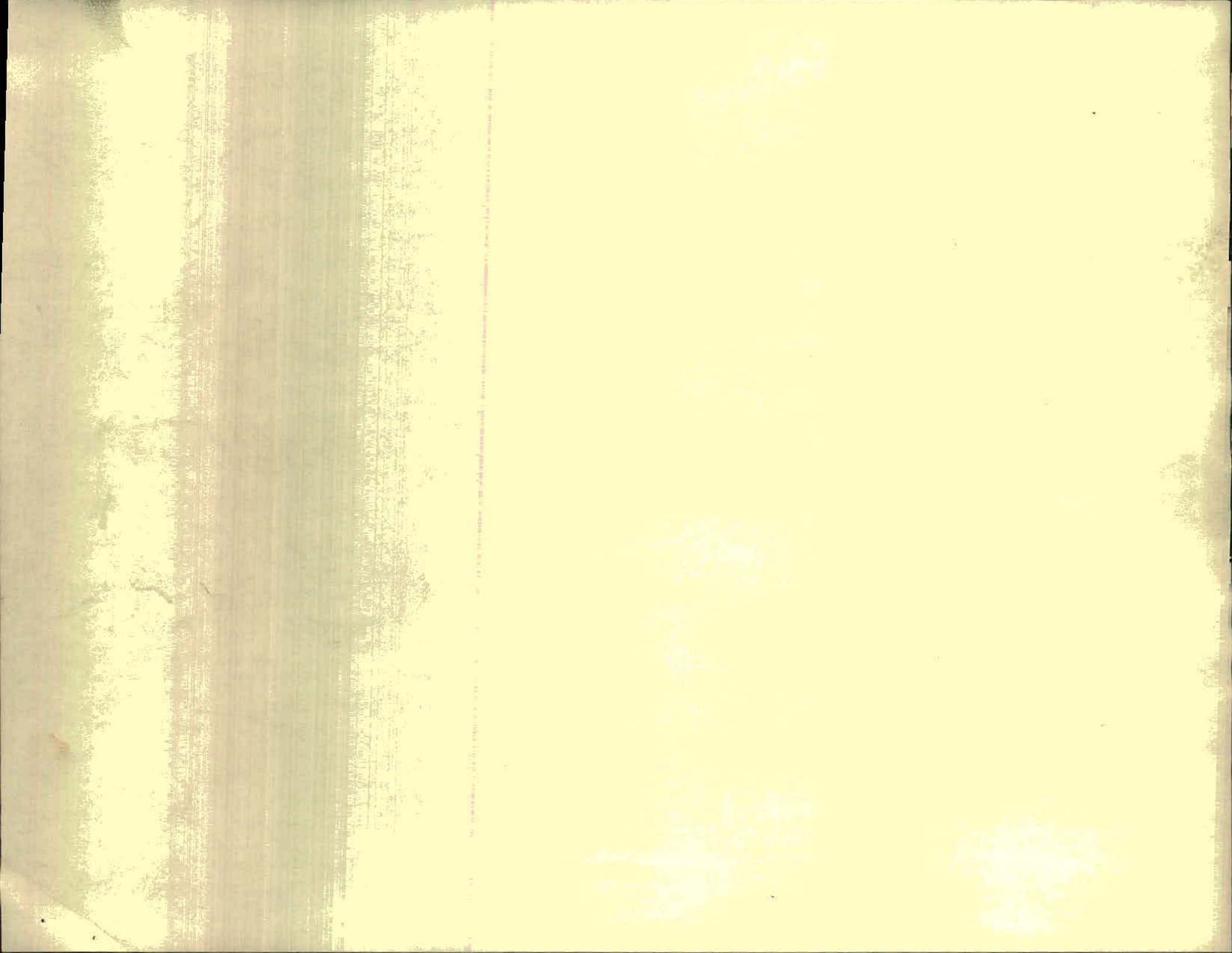
M304TR0.500W.035		Purchased	No			110	f	172.5474	1.25	13.15789			
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M304TR0 500W 035

304 RD Tube .500 x .035W

**

Location	Loc Qty	Loc Code
MAT017	172.5473823	
115535	0.913	
116720	1.66068	
117598	7.6415923	
119160	4.79	
119644	2.1209	
120633	155.42121	



Picklist Print

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Parent Item Name: Lid Prop Assembly 6.69" long

84006

D2332-041

Start Date: 01/05/2012

Start Qty: 10.00

Required Date: 15/05/2012

Required Qty: 10.00

AN4-4A

Purchased

No

170

Each

83.0000

1

10

AN4-4A

Bolt

**

(4) FF 12-08-13

Location

Loc Qty

Loc Code

FP001

6

114615

6

ST355

77

120187

31

121285

46

170

Each

8.0000

3

30

AN960JD416L

NAS1149D0416J

Purchased

No

*AN960.ID416I *

Washer

**

12

(4) FF 12-08-13

Location

Loc Qty

Loc Code

FP002

8

120910

8

110153

170

Each

5.520.000

1

10

MS21042L4

Purchased

No

MS21042I 4

Nut

**

4

(4) FF 12-08-13

Location

Loc Qty

Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

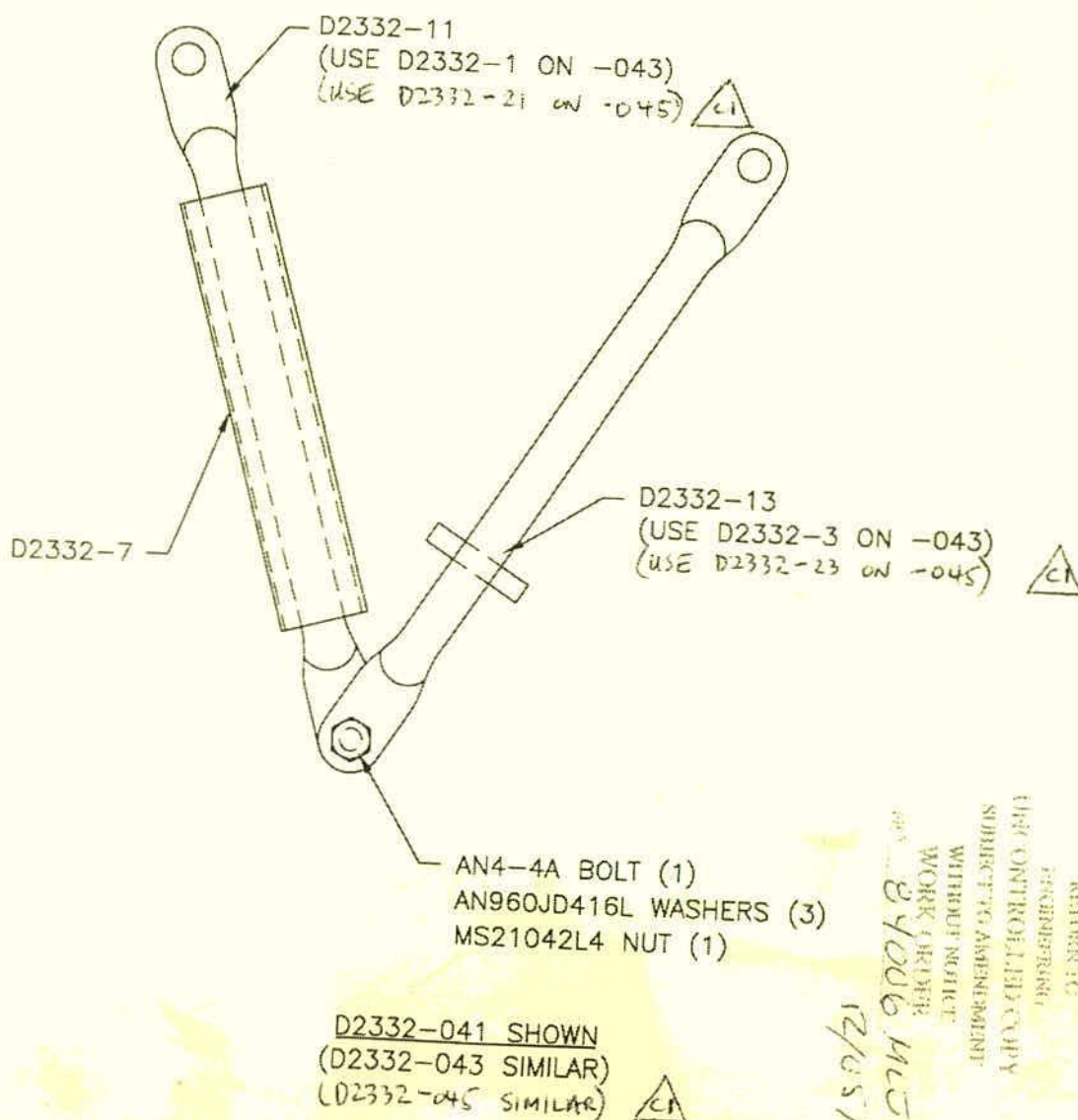
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Shop Packet Print

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	



DART



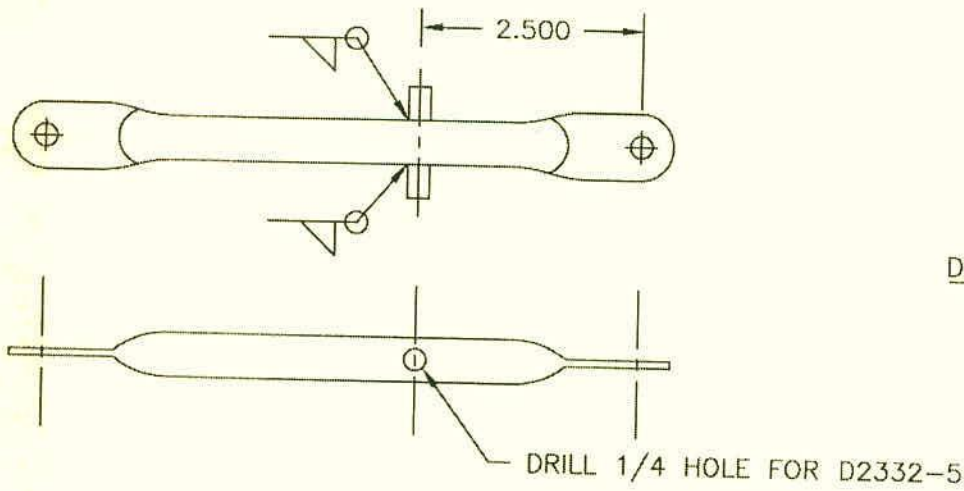
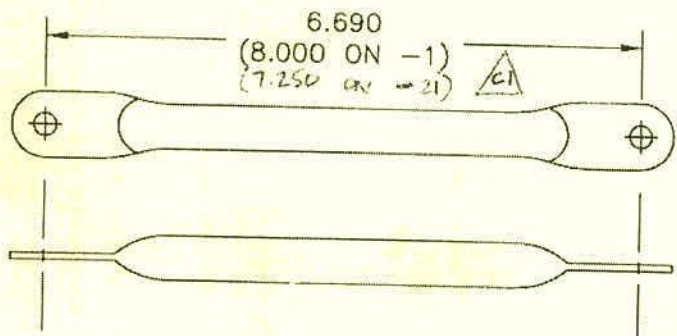
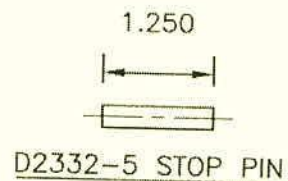
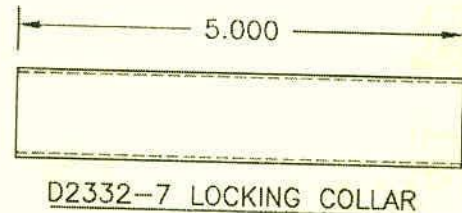
DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	TITLE	SCALE
C	03.07.03	D2332	LID PROP ASSEMBLY	1:2
C	03.07.03			
C	03.08.06			

REV. C
SHEET 2 OF 2

CHECKED	APPROVED	DATE
		03.07.03
		03.08.06

34006



D2332-13
M/F D2332-11 & D2332-5
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

- NOTES:
- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
 - TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

